

Work Order ID 75040

October-17-11 10:31:16 AM

75040

Page 1

Item ID: D3535-25

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Wearshoe

Stop

NS2

Start Date: 17/10/2011 Start Qty: 12.00

12

Cust Item ID:

Required Date: 27/10/2011 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: M.L. J

Date: 11/10/11

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								
100		0.00							

100

FLOW WATER JET

Waterjet

FLOW CNC Waterjet

304.046

Memo

0.00

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary B11-10-26

B11-10-26

(17)

110

QC2- Inspect parts off machine FAI/FAJB

0.00

B11-10-26

110

QC

Quality Control

Memo

0.00

120

QC8- Inspect parts - second check

0.00

Su 11-10-26

120

QC

Quality Control

Memo

0.00

(17)

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75040

October-17-11 10:31:16 AM

75040

Page 2

Item ID: D3535-25

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N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearshoe

Stop *NS2*

Start Date: 17/10/2011 Start Qty: 12.00

12

Cust Item ID:

Required Date: 27/10/2011 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Brake NC

NC BRAKE

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

(12)

140

140

QC

QC5- Inspect part completeness to step on W/O

0.00

W/ 11-11-01 (12)

Memo

0.00

150

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

3:45

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200F

475

M118436

12x 11/11/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75040

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Page 3

Item ID: D3535-25

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Item Name: Wearshoe

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Start Date: 17/10/2011 Start Qty: 12.00

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Cust Item ID:

Required Date: 27/10/2011 Req'd Qty: 12.00

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Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00

12 BR 16-11-2-

160

QC

Quality Control

170 Identify as per dwg & Stock Location: FP-1

0.00

12 BR 16-11-2.

170

Packaging

Packaging

180 QC21- Final Inspection - Work Order Release

0.00

11/11/11

180

QC

Quality Control

11/11/11
(P)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:31:21 AM

Page 1

Work Order ID: 75040

75040
D3535-25

Parent Item: D3535-25

Parent Item Name: Wearshoe

Start Date: 17/10/2011

Required Date: 27/10/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	137.0795	0.51	6.442105	**	B11-10	

M304S20GA

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	137.0795	
116623	0.2	
117550	8.363	
117933	43.3442	
118400	25.6723	
118964	59.5	
	119346	

119346

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25040
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

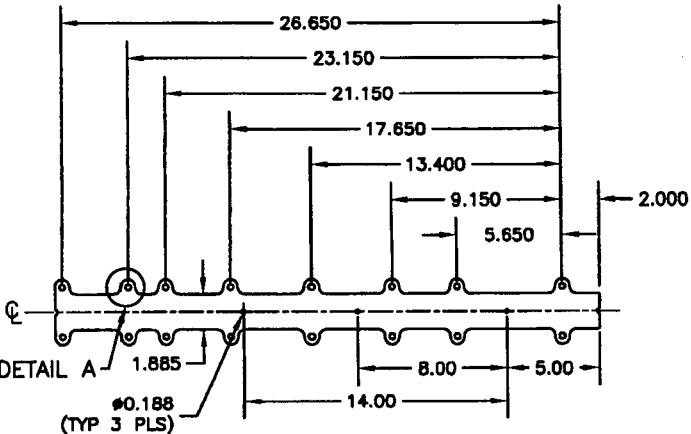
X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>11-10-26</u>	Date: <u>11/10/28</u>	Date: N/A

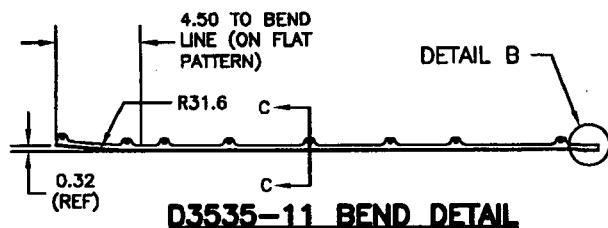
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

DART

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CB	RT	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>TM</i>	<i>TM</i>	D3535
DATE		REV. B
07.04.17		SHEET 1 OF 7
A	06.10.25	SCALE
B	07.04.17	1:10
		WEARSHOE
		MOVE TAB OUTBOARD, ADD AMS SPEC



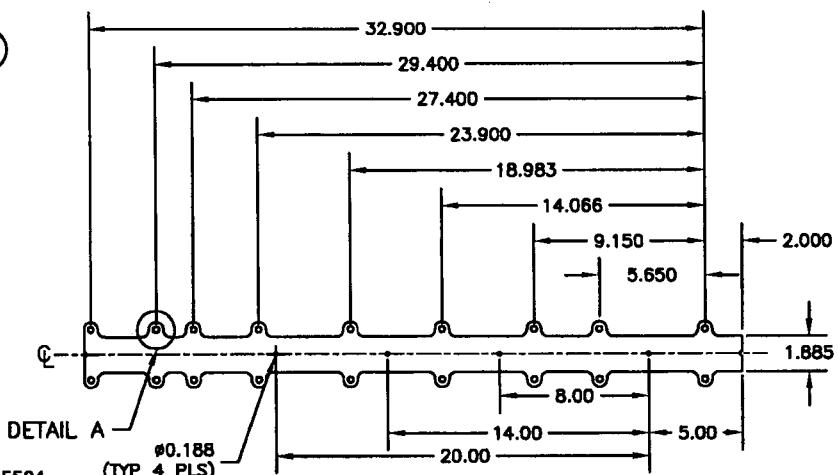
D3535-11F FLAT PATTERN



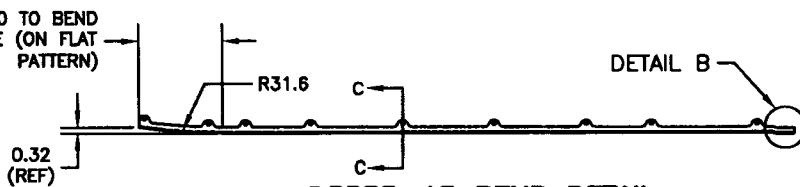
D3535-11 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75040

PL 11/10-17



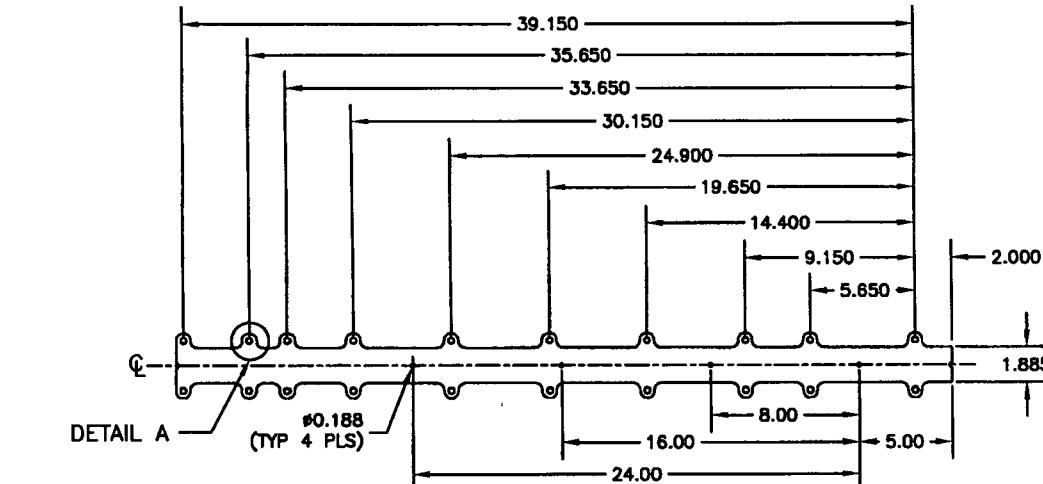
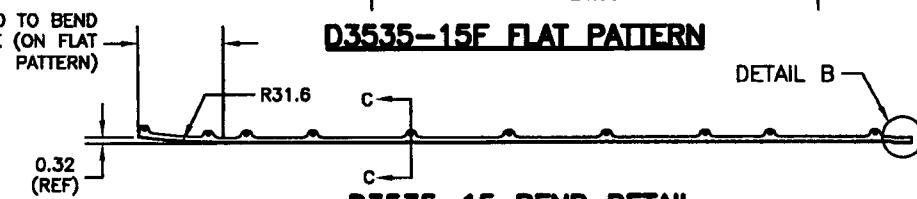
D3535-13F FLAT PATTERN



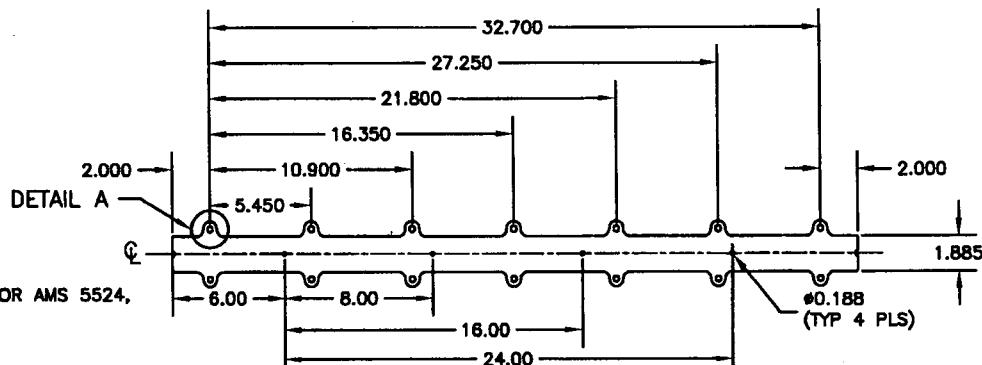
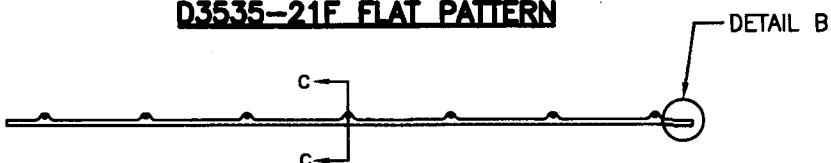
D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DARTRELEASED
07.04.17**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL**

750410

**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

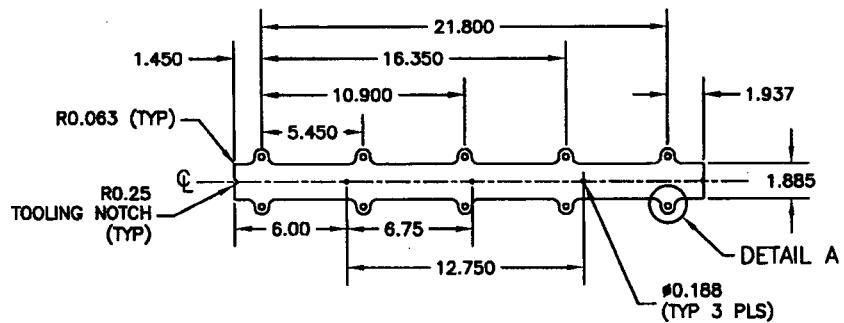
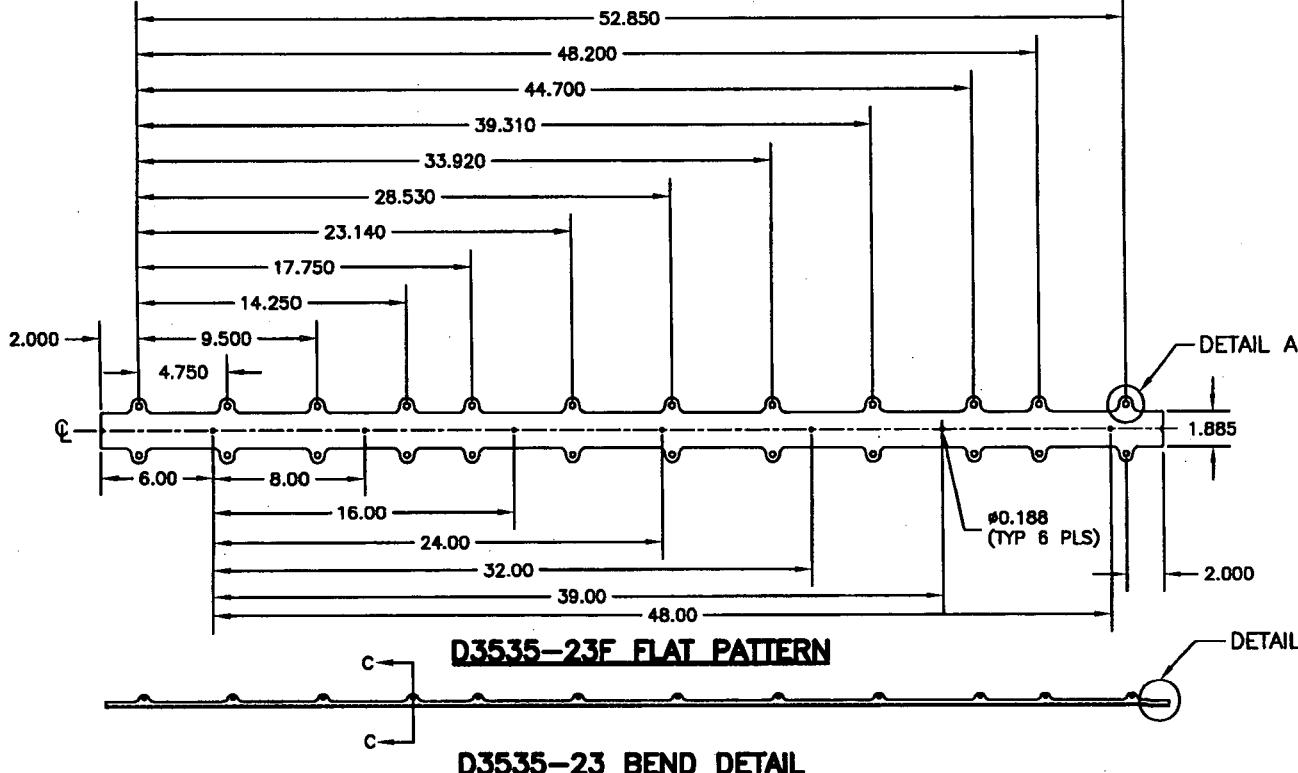
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CB	CH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
CH	CH	D3535
DATE		TITLE
07.04.17		WEARSHOE
		SCALE
		1:10
		REV. B
		SHEET 2 OF 7

DART

DESIGN CB	DRAWN BY AT	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED AT	APPROVED AT	DRAWING NO. D3535
DATE 07.04.17		SCALE 1:10
		NOTE SHEET 3 OF 7

RELEASED
07.04.24 - **AT**

75040

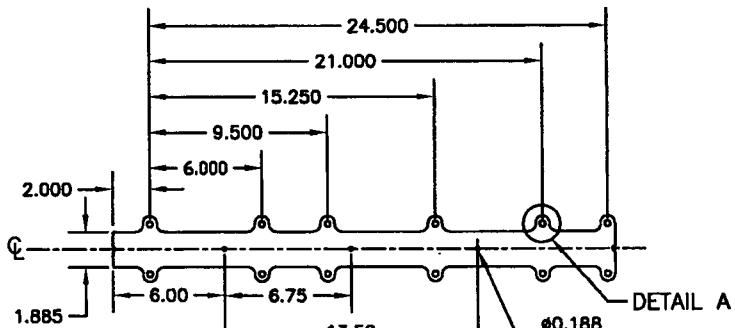
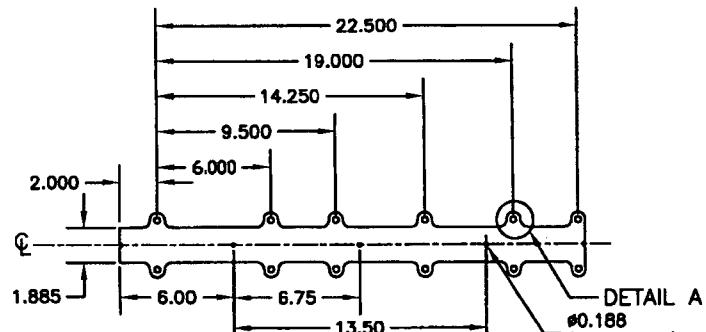
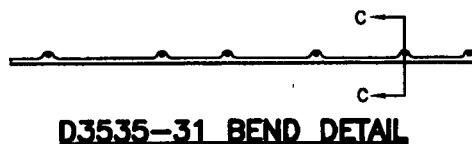


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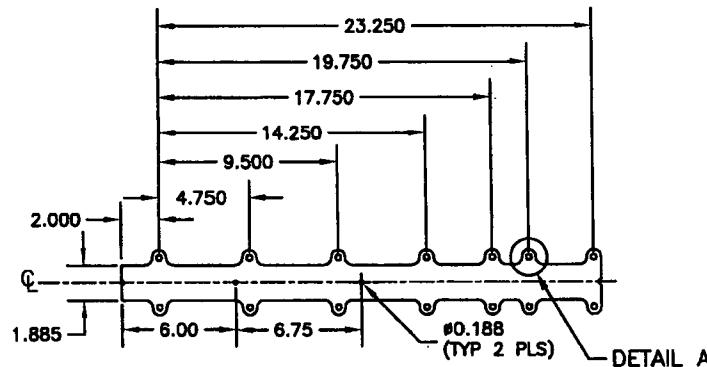
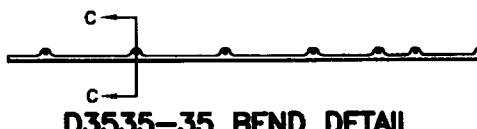
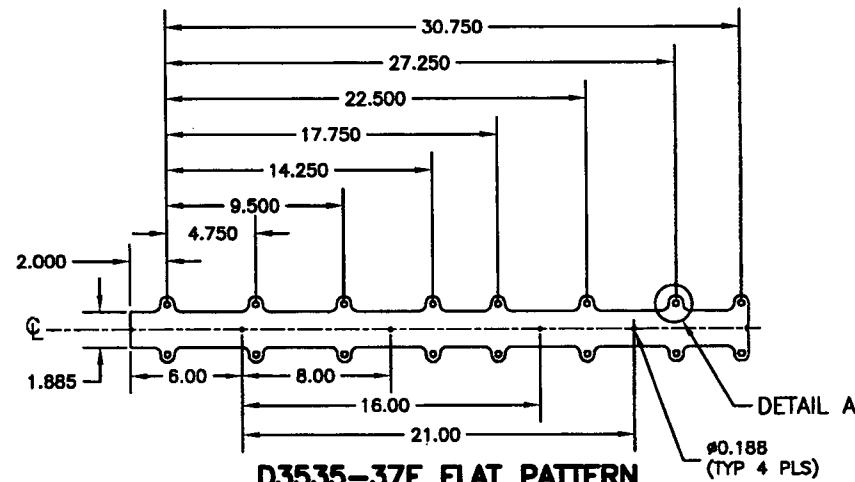
DESIGN	C.B	DRAWN BY	<i>MM</i>	DART AEROSPACE USA, INC.
CHECKED	<i>MM</i>	APPROVED	<i>MM</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REV. B SHEET 4 OF 7
		WEARSHOE		SCALE 1:10

RELEASED
07.04.17

75040

**D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL****D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****NOTES**

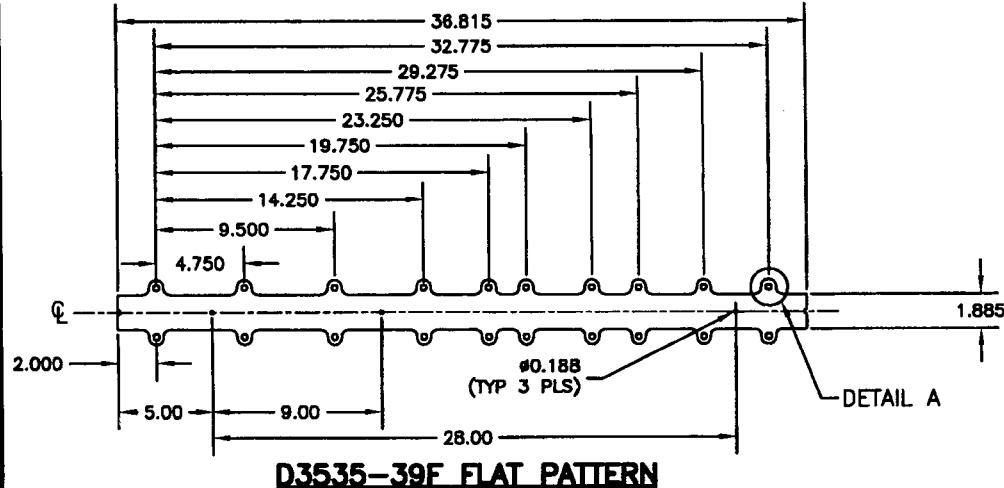
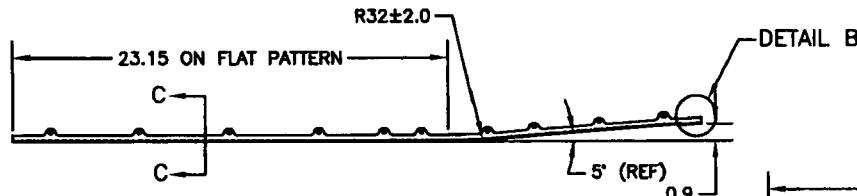
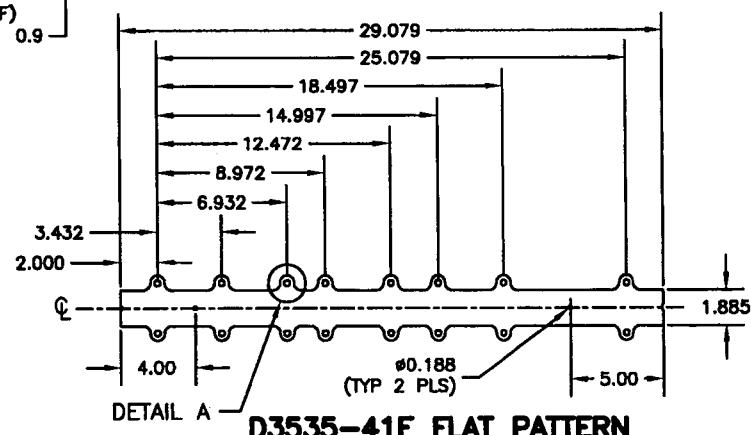
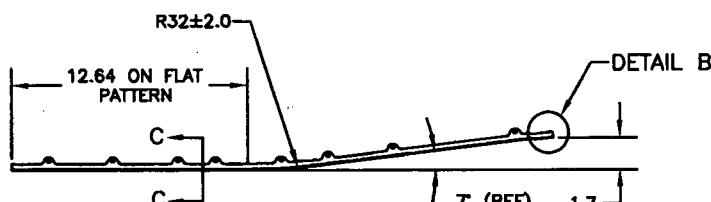
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DARTRELEASED
07.04.17**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

DESIGN C.B	DRAWN BY RJ	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 5 OF 7 SCALE 1:10

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DARTRELEASED
07.04.24**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C8	PH	PORT HADLOCK, WA
		REV. B
CHECKED	APPROVED	DRAWING NO.
		D3535
		WEARSHOE
DATE		SCALE
07.04.17		1:10

DART

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED ✓	APPROVED ✓	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE

REV. B

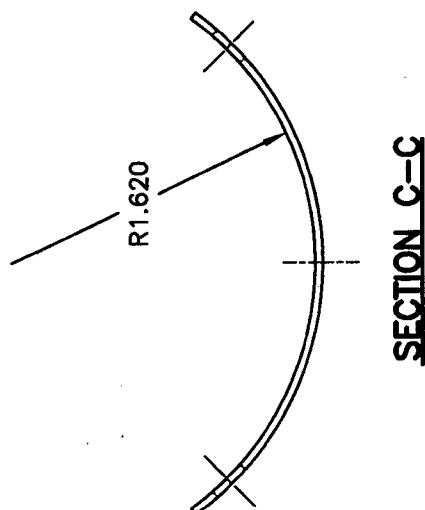
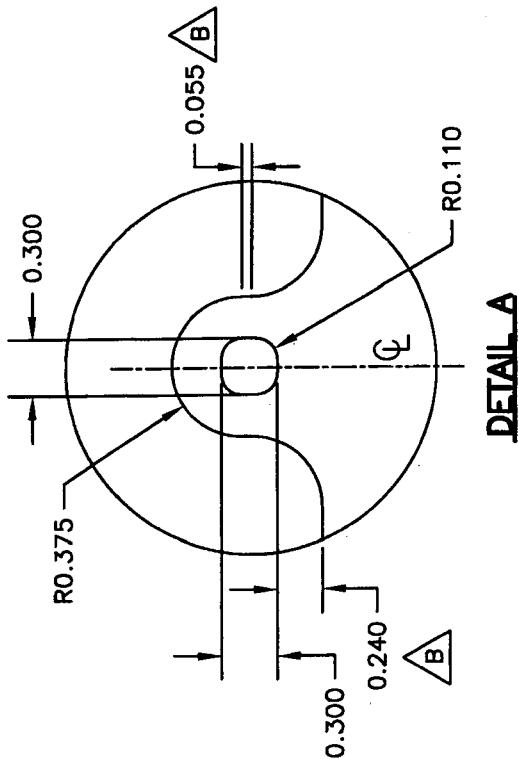
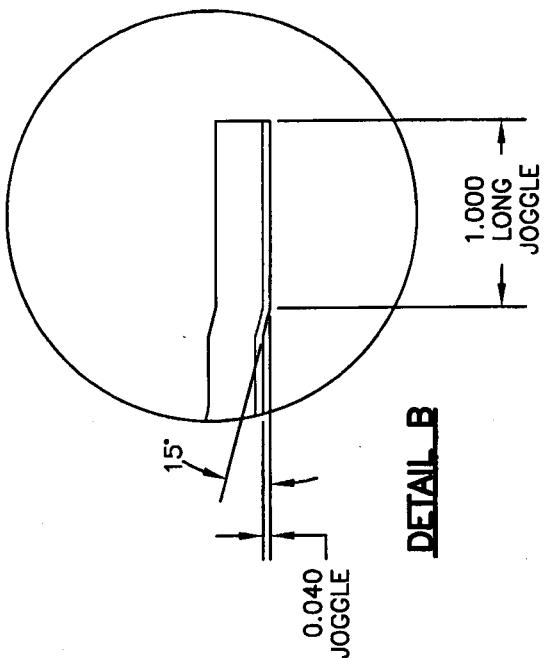
SHEET 7 OF 7

SCALE

1:1

RELEASED07.04.24 ~~✓~~

15040



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